

## ABSTRACT OF THE DISCLOSURE

A method for the production of pistons having depression edge armoring for internal combustion engines, in which a more heat-resistant armoring ring, in comparison with a forged piston blank having a combustion depression, is connected with the piston blank in the region of the depression edge. The method comprises the following steps:

a first piston blank is set on a projection of the armoring ring in the region of the depression edge;

the armoring ring is connected with the first piston blank by friction-welding;

a second piston blank is set onto the projection of the armoring ring, in such a manner that the two piston blanks do not touch;

the second piston blank is connected with the armoring ring by means of friction-welding;

the armoring ring is cut between the piston blanks, and

the pistons are given their final shape by a cutting work method.